

DT 8730

-003



Dart Aerospace Ltd.
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Canada

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D2667-1
Job Sheet 192273



Part No: D2667-1

Job Qty: 4 pcs

Part Name: Saddle, LH, Aft, Out



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/20/19

Job Tracking No:

Due Date: 4/5/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D IPP: C 00.11.01 Removed P/O for Powder Coat - in house process EC IPP Rev:D As per Rev D 07-03-19 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	4 pcs	4/5/19	4/5/19	0.00	6.96	HAAS - 1		SBL 19/03/27
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
110	Conventional Mill - 1 - B4B	4 pcs	4/5/19	4/5/19	0.00	6.96	Conventional Mill - 1 - B4B		VHJ 19/03/28
							Conventional Mill - 2 - B4B		
120	QC 2	4 pcs	4/5/19	4/5/19	0.00	0.00	QC 2 - 1		VHJ 19/03/28
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		



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Container No: S166732



Part: D2667-1

Job No: 192273

Serial No/Batch: S166732

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 03/27/19

130 QC 8	4 pcs	4/5/19	0.00 0.00	QC 2 - 56	
				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	BF 19-03-28
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
140 Handfinish - 1-1 Chemical-B4B	4 pcs	4/5/19	0.00 0.27	QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
150 Powdercoat - 1 White Gl(A)-B4B	4 pcs	4/5/19	0.00 0.22	Handfinish - 1 - 10 - B4B	D.R 19/03/29
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
				Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	BR 19-03-29
				Powdercoat - 4 - B4B	

160 QC 3	4 pcs	4/5/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
170 Packaging 3-1 - Stock - B4B	4 pcs	4/5/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
180 QC 21 - SA	4 pcs	4/5/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - Program batch number. 1-Inspect part number and batch number are programmed correctly. 3-Fixturing Inspection
 Descriptions: last completed on _____ by _____ 4-Machine Step No 1 of Folio and visually inspect as per attached Dimension
 Sheet 5-Machine Step No 2 of F

110 - Machine Keyway and inspect per attached dimension sheet

120 - QC2- Inspect parts off machine FAI/FAIB

130 - QC8- Inspect parts - second check

140 - Chemical Conversion Coat per QSI005 4.1

150 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum START TIME: 8:20 OVEN TEMPERATURE: 320°

FINISH TIME: 8:50 M138997

160 - QC3- Inspect Part Finish

170 - Identify as per dwg & Stock Location:

180 - QC21- Final Inspection - Work Order Release

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D6101-003	Saddle Billet, 7075	4 pcs (1 ea)	100-HAAS 4 Axis	S134 199
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	D6101-003	4	46	0
Part Specifications				
Specifications could not be found.				

Plex 3/20/19 11:03 AM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order: 192273
Description: 206 Saddle, Outboard, Left side		Part Number: D2667-1
Inspection Dwg: D2667 Rev: D DSK: Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		0.121	0.121	0.122	0.122	
B	0.100	0.140		0.118	0.123	0.122		
C	1.125	1.145	✓	1.135	1.135	1.135	1.135	
D	0.615	0.685	✓	0.650	0.650	0.650	0.650	
E	0.240	0.260		0.254	0.253	0.253		
F	1.313	1.343		1.324	1.324	1.324	1.324	
G	0.210	0.230		0.222	0.222	0.223	0.223	
H	0.100	0.180	✓	0.130	0.130	0.130	0.130	
I	2.470	2.510	✓	2.500	2.500	2.500	2.500	
J	1.565	1.585	✓	1.575	1.575	1.575	1.575	
K	0.235	0.240		0.239	0.239	0.239	0.238	
L	0.100	0.120		0.116	0.120	0.120	0.120	
M	0.990	1.010	✓	1.005	1.005	1.005	1.005	
N	0.510	0.515		0.511	0.512	0.511	0.512	
O	5.990	6.010		5.996	5.997	5.998	5.999	
P	1.245	1.255	✓	1.250	1.250	1.250	1.250	
Q	2.495	2.505	✓	2.500	2.500	2.500	2.500	
R	0.312	0.318	✓	0.312	0.312	0.312	0.312	
S	0.315	0.322	✓	0.316	0.316	0.316	0.316	
T	1.995	2.005	✓	2.000	2.000	2.000	2.000	
U	1.357	1.367	✓	1.362	1.362	1.362	1.362	
V	0.787	0.807		0.793	0.798	0.797	0.797	
W	1.040	1.060	✓	1.047	1.052	1.051	1.050	
X	1.674	1.679	✓	1.679	1.679	1.679	1.679	
Y	0.256	0.262	✓	0.257	0.257	0.257	0.257	
Z	0.912	0.932		0.923	0.924	0.924	0.924	
AA	0.490	0.510		0.501	0.503	0.504	0.504	
AB	0.178	0.198	✓	0.188	0.188	0.188	0.188	
AC								
AD								
AE								
Accept/Reject								

Measured by: SBZ VHP	Date: 19/03/27
Audited by: 20	Date: 19-03-28
Prototype Approval: 989	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.03.08	Revised dimensions R and Y	KJ	AA

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					